

**Work Order ID 57294**

Page 1

Wednesday, March 31, 2010 3:41:19 PM

Item ID: D4035-047

Accept



Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Aft (Light)

Stop



Start Date: 3/31/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 4/5/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-3-31 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4035	A

100	Weld per dwg A/R Aluminum rod Batch: M 111 386	0.00
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Large Fab

Memo 0.00

Large Fab

- 1- Cut D4035-7 as per dwg D4035
- 2- Drill hole using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

2X  
m-f w/04/02  
EL 10-4-5 x2

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
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QC

Memo 0.00

Quality Control

10.04.05

④

Dart Aerospace Ltd D Y060-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4035-047 PAR #: \_\_\_\_\_ Fault Category: Small Fail NCR:  Yes No DQA:  Date: 10/04/06  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed:  Date: 10/04/06

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/06 100	#	• 375" holes were drilled off center. Parts were done on the Drill Press. LC employee didn't know about the Drill S.g. LDA.	<input checked="" type="checkbox"/> 10/04/06 100	Scrap + destroy off +/ Replace M 103069	<input checked="" type="checkbox"/> 10/04/06 M.P.	<input checked="" type="checkbox"/> S 10/04/06	<input checked="" type="checkbox"/> 10/04/06 100	<input checked="" type="checkbox"/> S 10/04/06
			<input checked="" type="checkbox"/> 10/04/06 100			<input checked="" type="checkbox"/> 10/04/06 100	<input checked="" type="checkbox"/> 10/04/06 100	<input checked="" type="checkbox"/> 10/04/06 100

NOTE: Date &amp; initial all entries

**Work Order ID 57294**

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Wednesday, March 31, 2010 3:41:19 PM

Item ID: D4035-047

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Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Aft (Light)

Stop



Start Date: 3/31/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 4/5/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

S 104106

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: box 0.00

Memo

0.00

② PD 10.04.06

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/07 JH

MF  
10-4-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, March 31, 2010 3:41:19 PM

Page 1  
T

Work Order ID: 57294



Parent Item: D4035-047



Parent Item Name: Lid Rib Assembly, Aft (Light)

Start Date: 3/31/2010

Required Date: 4/5/2010

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4035-11		Manufactured	No			100	Each	8.0000	4.0000			



Bushing

## Warehouse

### Location

Main Warehouse

ST109	8
56958	8

M6061T6TS0.750W.06

2



6061-T6 SQ Tube .75 x .75 x .062W

Purchased

No

## Warehouse

### Location

Main Warehouse

MAT06	165.1568
103069	51.0968
104422	69.75
16441	10.31
9671	34

4X M-f  
10/04/02

1.9737

1.9737

M-f  
10/04/02

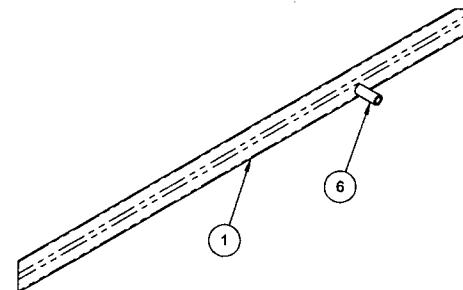
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

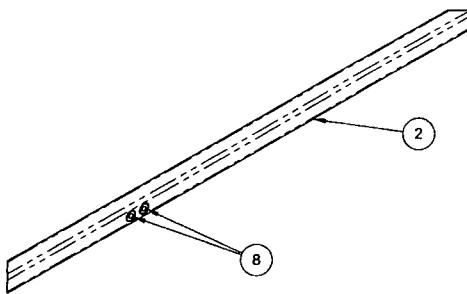
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

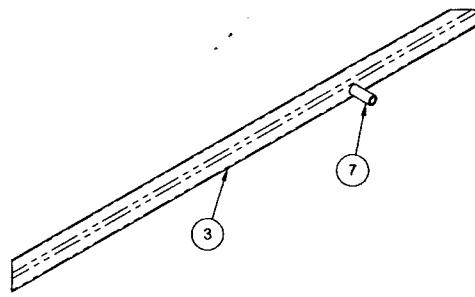
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
D	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



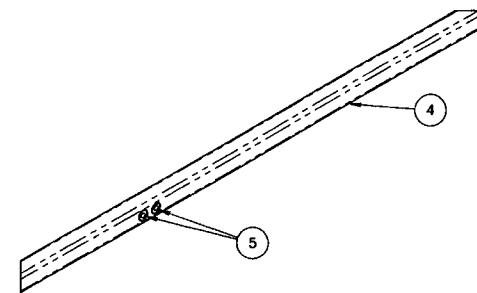
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED  
R 2010-03-12  
W

457094

A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS			
DRAWN	JPH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.03.04		SCALE	NTS

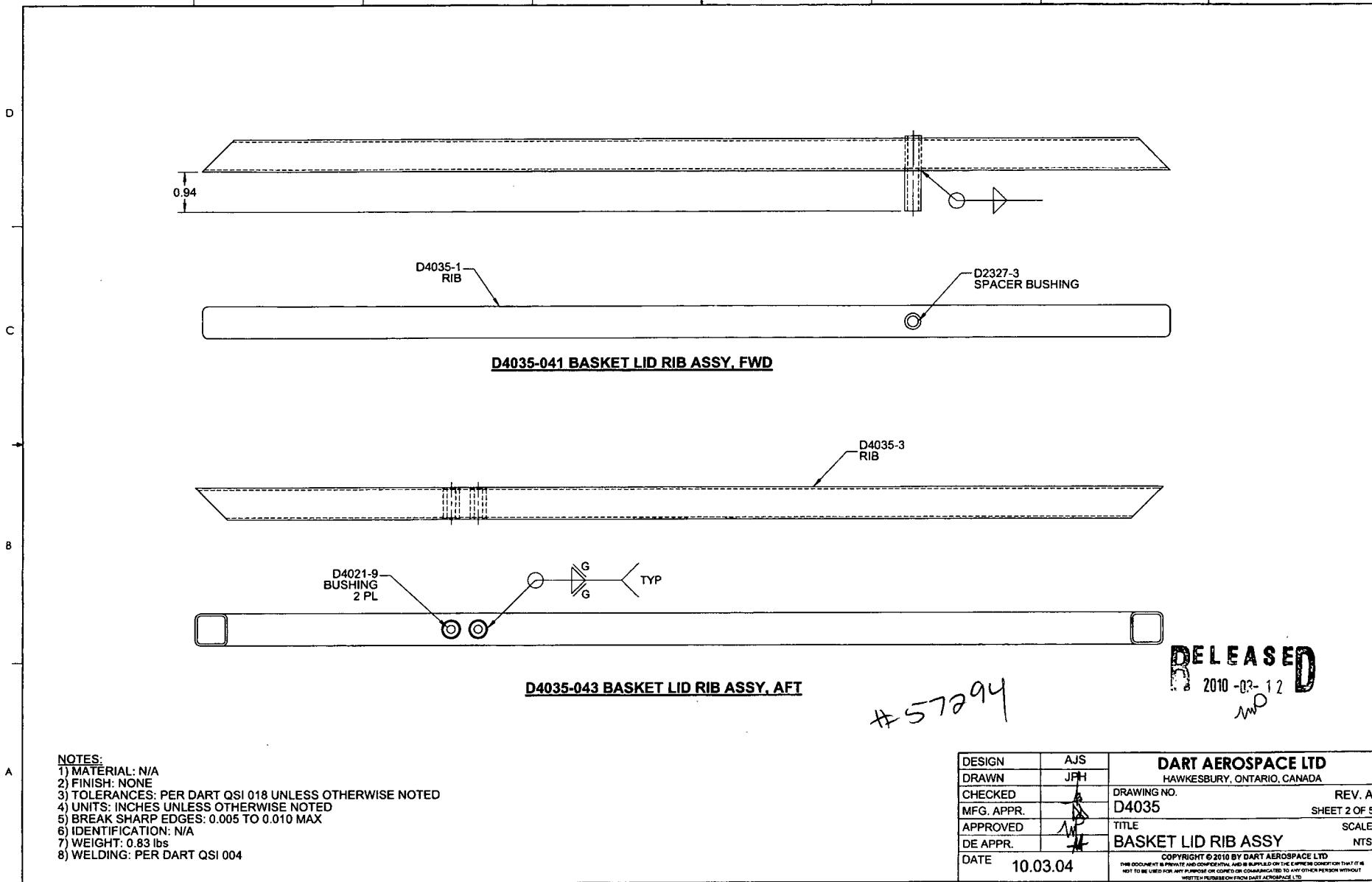
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A  
D4035 SHEET 1 OF 5

TITLE: BASKET LID RIB ASSY

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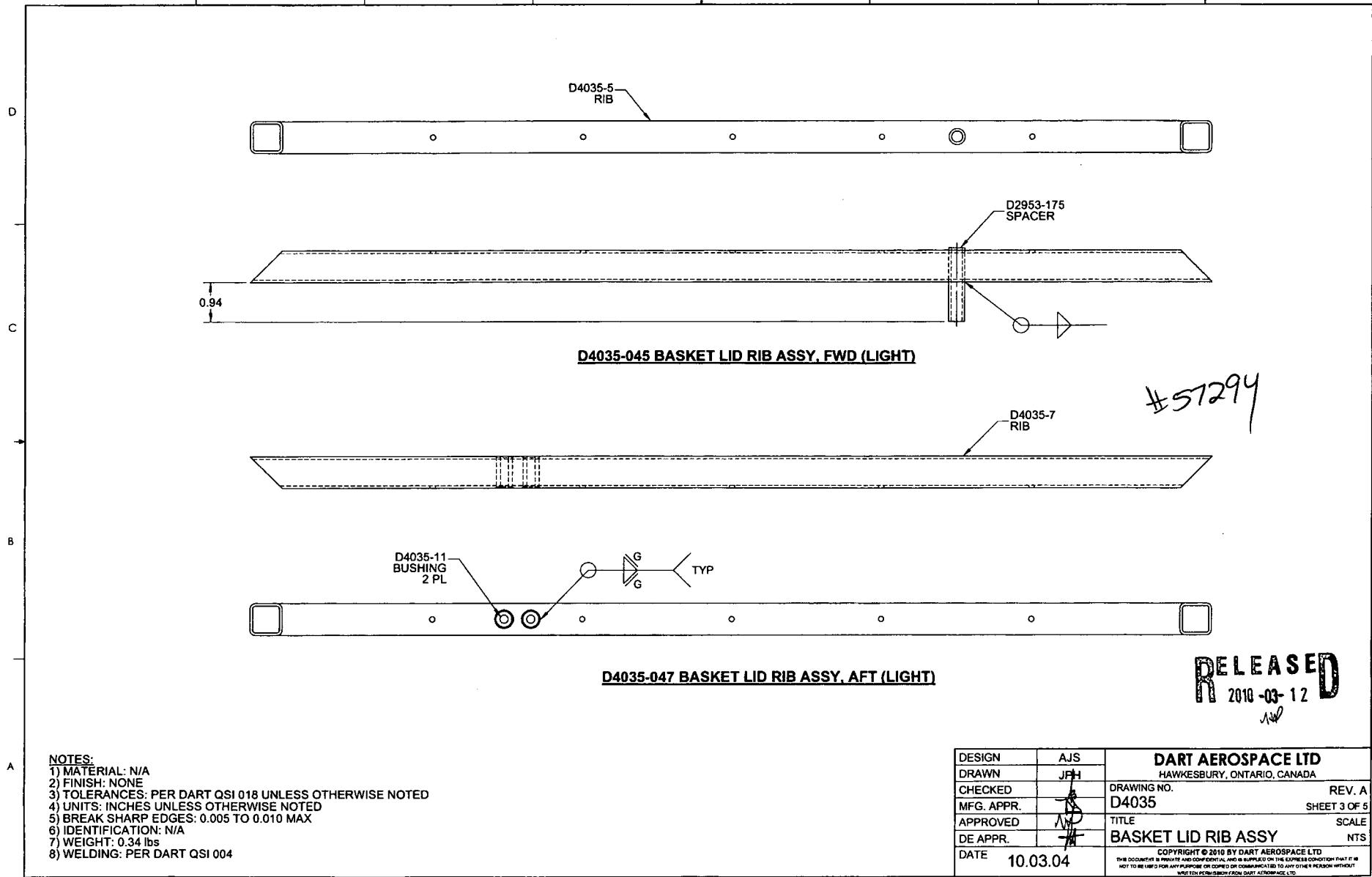


DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JFH	
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D4035
DE APPR.		SHEET 2 OF 5
DATE	10.03.04	TITLE BASKET LID RIB ASSY SCALE NTS

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